



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D135-751-011
Job Sheet 203381



Part No: D135-751-011

Job Qty: 1 pcs

Part Name: Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/18/19

Job Tracking No:

Due Date: 11/29/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG DSI 9661 REV A, D3507 REV D IPP Rev:A 44353 New Issue JLM IPP Rev:B 06-12-18 As per Rev B
JLM IPP Rev:C 07-12-11 ECN 1036 as per revB DD IPP Rev D 08.11.04 Added DT9431 to sequence 5 EC
verf DD IPP Rev E 10.02.22 per PAR 09-043 EC verified: DD IPP Rev:F 10.06.09 remove seq110 DD verf:EC
IPP Rev G 10.09.17 added D3507-1-bent EC verified:DD IPP REV:H 13.12.11 ECN13-619/ CHG002 DD
VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Skidtubes - 1	1 pcs		11/29/19	0.00	4.60	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		BE
							Skidtubes - 6		
							Skidtubes - 7		
140	QC 5	1 pcs		11/29/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		NOV 20 2019 DAS 68
							QC 5 - 9		9-89
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
150	Handfinish - 1-1 Chemical-B4B	1 pcs		11/29/19	0.00	0.33	Handfinish - 1 - 1 - B4B		BER 19-11-21
							Handfinish - 1 - 2 - B4B		

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					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
160 QC 7	1 pcs	11/29/19	0.00	0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	

170 Skidtubes - 2 - B4B	1 pcs	11/29/19	0.00 1.00	QC 7 - 61	
				QC 7 - 81	
				QC 7 - 76	
				QC 7 - 79	
				Skidtubes - 1 - B4B	DD
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
180 QC 10	1 pcs	11/29/19	0.00 0.00	Skidtubes - 5 - B4B	BE
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
				QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	
185 Handfinish - 6-1- Touch Up- B4B	1 pcs	11/29/19	0.00 0.10	QC 10 - 58	
				QC 10 - 9	DAS
				QC 10 - 68	NOV 28 2019 68
				Handfinish - 6 - 1 - B4B	9-89
				Handfinish - 6 - 2 - B4B	
				Handfinish - 6 - 3 - B4B	NOV 29 2019
				Handfinish - 6 - 4 - B4B	
				Handfinish - 6 - 5 - B4B	
				Handfinish - 6 - 6 - B4B	
				Handfinish - 6 - 7 - B4B	
				Handfinish - 6 - 8 - B4B	
				Handfinish - 6 - 9 - B4B	
				Handfinish - 6 - 10 - B4B	
				Handfinish - 6 - 11 - B4B	
				Handfinish - 6 - 12 - B4B	
				Handfinish - 6 - 13 - B4B	
				Handfinish - 6 - 14 - B4B	
				Handfinish - 6 - 15 - B4B	
				Handfinish - 6 - 16 - B4B	
				Handfinish - 6 - 17 - B4B	
				Handfinish - 6 - 18 - B4B	
				Handfinish - 6 - 19 - B4B	
				Handfinish - 6 - 20 - B4B	
				Handfinish - 6 - 21 - B4B	
				Handfinish - 6 - 22 - B4B	
187 QC 7	1 pcs	11/29/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	

					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
					QC 7 - 79	
190 Skidtubes - 3 - B4B	1 pcs	11/29/19	0.00 1.00	Skidtubes - 1 - B4B		
				Skidtubes - 2 - B4B		
				Skidtubes - 3 - B4B		
				Skidtubes - 4 - B4B		
				Skidtubes - 5 - B4B		
				Skidtubes - 6 - B4B		
				Skidtubes - 7 - B4B		
200 QC 5	1 pcs	11/29/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		
				QC 5 - 61		
				QC 5 - 81		
210 Handfinish - 2-1 Pressure-B4B	1 pcs	11/29/19	0.00 0.08	Handfinish - 2 - 1 - B4B		
				Handfinish - 2 - 2 - B4B		
				Handfinish - 2 - 3 - B4B		
				Handfinish - 2 - 4 - B4B		
220 Spray Paint - 2 - B4B	1 pcs	11/29/19	0.00 0.25	Spray Paint - 1 - B4B		
				Spray Paint - 2 - B4B		
				Spray Paint - 3 - B4B		
				Spray Paint - 4 - B4B		

100

DAS
DEC 02 2019 68
9-89

DEC 03 2019

DAS
41 DEC 06 2019
9-89

225 QC 14	1 pcs	11/29/19	0.00 0.00	QC 14 - 15	
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	BEB 19-12-09
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
				QC 14 - 61	
				QC 14 - 81	
260 Handfinish - 4-1-Assembly-B4B	1 pcs	11/29/19	0.00 0.74	Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	BEB 19-12-09
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
270 QC 5	1 pcs	11/29/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	DAS 40
				QC 5 - 61	DEC 15 2019 9-89
				QC 5 - 81	
280 Packaging 1-1 - Pick Kit - B4B	1 pcs	11/29/19	0.00 0.00	Packaging 1 - 1 - B4B	
				Packaging 1 - 2 - B4B	
				Packaging 1 - 3 - B4B	
				Packaging 1 - 4 - B4B	
				Packaging 1 - 5 - B4B	

DAS
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9-89

DAS
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DAS
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9-89

					Packaging 1 - 6 - B4B	
					Packaging 1 - 7 - B4B	
					Packaging 1 - 8 - B4B	
					Packaging 1 - 9 - B4B	
					Packaging 1 - 10 - B4B	
					Packaging 1 - 11 - B4B	
					Packaging 1 - 12 - B4B	
					Packaging 1 - 13 - B4B	
					Packaging 1 - 14 - B4B	
					Packaging 1 - 15 - B4B	
					Packaging 1 - 16 - B4B	
					Packaging 1 - 17 - B4B	
					Packaging 1 - 18 - B4B	
					Packaging 1 - 19 - B4B	
					Packaging 1 - 20 - B4B	
					Packaging 1 - 21 - B4B	
					Packaging 1 - 22 - B4B	
					Packaging 1 - 23 - B4B	
					Packaging 1 - 24 - B4B	
					Packaging 1 - 25 - B4B	
					Packaging 1 - 26 - B4B	
					Packaging 1 - 27 - B4B	
					Packaging 1 - 28 - B4B	
					Packaging 1 - 29 - B4B	
					Packaging 1 - 30 - B4B	
					Packaging 1 - 31 - B4B	
					Packaging 1 - 32 - B4B	
					Packaging 1 - 33 - B4B	
					Packaging 1 - 34 - B4B	
					Packaging 1 - 35 - B4B	
					Packaging 1 - 36 - B4B	
290 QC 4	1 pcs	11/29/19	0.00 0.00		QC 4 - 28	
					QC 4 - 58	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
					QC 4 - 68	
					QC 4 - 72	
					QC 4 - 74	
					QC 4 - 75	
					QC 4 - 78	
300 Packaging 3-1 - Stock - B4B	1 pcs	11/29/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	

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9-89 DEC 18 2019

					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	DAS 78
					Packaging 3 - 26 - B4B	9-89 DEC 1 8 2019
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	DAS 21
305 DC - 1 - B4B	1	11/29/19	0.00 0.00		DC - 1 - B4B	21
	pcs				DC - 2 - B4B	9-89 DEC 1 8 2019

310 QC 21 - FG	1	11/29/19	0.00 0.00		QC 21 - FG - 21	DAS 21
	pcs				QC 21 - FG - 70	21
					QC 21 - FG - 53	9-89 DEC 1 8 2019

Part Op 120 - 1-Cut Aft end as per dwg D3507 3-Drill Aft & Fwd Cap holes using DT8878 & DT8901 4-Locate DT8870 & Drill
Descriptions: Ground wire hole on top of Tube. 6-Locate DT8870 with #30 cleco in Ground wire hole ,then Pilot Drill all X-Bolt holes using #30" drill. ****DO NOT OPEN AFT CAP HOLES***** 7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot holes for wearplates using Dt8868,Use DT8892 FOR REAR WEARPLATE HOLES. 8-Open six rear wearplate holes using DT8892.Open all wearplate holes to 0.297" 9-Open ground wire hole .297" section E-E 10-Open Aft & Fwd Cap holes using .208" drill. 11-Bore out aft end of tube as per Dwg D3507 & Detail "B". 12- Section G-G holes must be laid out manually, open to #30. 13-Deburr holes.
140 - (QC5- Inspect part completeness to step on W/O)
160 - (QC7-Inspect Chemical Conversion Coat)
170 - 1-Open X-Bolt holes to .375"(1 Places) & .500"(2Places) as per Dwg D3507. and section G-G to .750" (2 places) 2-Counter Sink X-BOLT holes as per Dwg D3507 3-Deburr and blow out chips from inside of tube. 4-Bond web as per Dwg D3507 & QSI 015 start time: 5:31/09:5 end time: 8:17/09:40 5-Weld x-bolt spacers as per Dwg D3507 and Detail C-C & D-D and G-G 7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B 8-Deburr Rivet holes.
180 - (QC10- Inspect visual per QSI004- ground welds)
185 - (Touch up alodine) RE-ALODINE ONLY
187 - (QC7-Inspect Chemical Conversion Coat)
190 - 1-Rivet D3506-1/-3 as per Dwg D3507.
200 - (QC5- Inspect part completeness to step on W/O)
210 - Touch-up alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.
220 - (Spray Paint / NDT Room) 1- Apply Primer as per QSI 005 4.2.1.3.3 and dwg A/R Primer
Batch: 5218188 2- Paint two coats of White paint as per QSI 005 4.2 and dwg A/R Paint
Batch: 5231052
225 - (QC14- Inspect Spray Paint)
260 - 1- Install Wearplate &Ground Wire inserts as per Dwg D3507. 1-Inspect for Foreign objects 2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B" 3-Install Wearplates as per Dwg D3507 , Note:Install (1) Bolt and (1) washer on Ground Wire insert on top of tube Do not Install Scews where Indicated on Dwg(Note #6) 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube 5- Wing Walk as per Dwg D3507 and QSI 005 4.4 Batch: 5229693
270 - (QC5- Inspect part completeness to step on W/O)
280 - (Pick Kit)
290 - (QC4- 100% Inspect kits for completeness)
300 - (Identify as per dwg & Stock Location:) Identify and pack for shipping as per PPP D135-751-011 PPP
Rev: _____
305 - Photocopy bluefile & type labels per PPP D135-751-011 CHG002
310 - QC21- Final Inspection - Work Order Release

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Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D3507-1-BENT	Skidtube Assembly EC135	1 pcs (1 ea)	120-Skidtubes - 1	5232838
D3504-1	Crossbolt Spacer	2 pcs (2 ea)	170-Skidtubes - 2 - B4B	5213143
D3504-3	Crossbolt Spacer	1 pcs (1 ea)	170-Skidtubes - 2 - B4B	5167823
D3504-5	Crossbolt Spacer	2 pcs (2 ea)	170-Skidtubes - 2 - B4B	5222146
D3505-1	Web	1 pcs (1 ea)	170-Skidtubes - 2 - B4B	5233016
D3506-1	Doubler	4 pcs (4 ea)	190-Skidtubes - 3 - B4B	5226738
D3506-3	Doubler	2 pcs (2 ea)	190-Skidtubes - 3 - B4B	5226736
MS20601-AD4W3	Rivet	12 Ea (12 ea)	190-Skidtubes - 3 - B4B	5221158
ALS4-1032-225	Rivnut	1 Ea (1 ea)	260-Handfinish - 4-1-Assembly-B4B	5203363
ALS7-1032-130	Rivnut	38 Ea (38 ea)	260-Handfinish - 4-1-Assembly-B4B	5209194
AN3C4A	Bolt	31 Ea (31 ea)	260-Handfinish - 4-1-Assembly-B4B	5220803-1
AN3C5A	Bolt	2 Ea (2 ea)	260-Handfinish - 4-1-Assembly-B4B	5123445
AN526C1032R10	Screw	2 Ea (2 ea)	260-Handfinish - 4-1-Assembly-B4B	5166981
D2965	Cap	1 pcs (1 ea)	260-Handfinish - 4-1-Assembly-B4B	5166570
D2965-3	Cap	1 pcs (1 ea)	260-Handfinish - 4-1-Assembly-B4B	5166571
D3492-1	Plug	4 pcs (4 ea)	260-Handfinish - 4-1-Assembly-B4B	5218656
D3492-3	Plug	4 pcs (4 ea)	260-Handfinish - 4-1-Assembly-B4B	5215332
D3492-7	Plug	2 pcs (2 ea)	260-Handfinish - 4-1-Assembly-B4B	5219515
D4918-047	Wearplate Aft	1 pcs (1 ea)	260-Handfinish - 4-1-Assembly-B4B	5218948
D4918-1	Wearplate Fwd	1 pcs (1 ea)	260-Handfinish - 4-1-Assembly-B4B	5220080
D4918-3	Wearplate Center Fwd	1 pcs (1 ea)	260-Handfinish - 4-1-Assembly-B4B	5220102
D4918-5	Wearplate Center Aft	1 pcs (1 ea)	260-Handfinish - 4-1-Assembly-B4B	5220109
NAS1149C0332R	Washer (AN960C10L)	33 Ea (33 ea)	260-Handfinish - 4-1-Assembly-B4B	5233308
NAS1611-007	O-Ring	2 Ea (2 ea)	260-Handfinish - 4-1-Assembly-B4B	E103697
NAS1611-010	O-Ring	4 Ea (4 ea)	260-Handfinish - 4-1-Assembly-B4B	5217830
NAS1611-013	O-Ring	4 Ea (4 ea)	260-Handfinish - 4-1-Assembly-B4B	5218787
AN3C4A	Bolt	8 Ea (8 ea)	280-Packaging 1-1 - Pick Kit - B4B	5213708
D3512-041	Wearplate	2 pcs (2 ea)	280-Packaging 1-1 - Pick Kit - B4B	5238483
NAS1149C0332R	Washer (AN960C10L)	8 Ea (8 ea)	280-Packaging 1-1 - Pick Kit - B4B	5215607

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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
120-Skidtubes - 1	D3507-1-BENT	1	0	0
170-Skidtubes - 2 - B4B	D3504-1	2	102	0
	D3504-3	1	94	0
	D3504-5	2	18	0
	D3505-1	1	5	0
	D3506-1	4	27	0
190-Skidtubes - 3 - B4B	D3506-3	2	28	0
	MS20601-AD4W3	12	736	0
	ALS4-1032-225	1	882	0
260-Handfinish - 4-1-Assembly-B4B	ALS7-1032-130	38	937	0
	AN3C4A	31	1,406	0
	AN3C5A	2	703	0
	AN526C1032R10	2	105	0
	D2965	1	32	0
	D2965-3	1	32	0
	D3492-1	4	104	0
	D3492-3	4	35	0
	D3492-7	2	36	0
	D4918-047	1	5	0
	D4918-1	1	6	0
	D4918-3	1	11	0
	D4918-5	1	11	0
	NAS1149C0332R	33	3,357	0
	NAS1611-007	2	214	0
	NAS1611-010	4	160	0
	NAS1611-013	4	62	0
	AN3C4A	8	1,406	0
	D3512-041	2	5	0
	NAS1149C0332R	8	3,357	0

Part Specifications
Specifications could not be found.

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Qty	Part Number	Description
1	D3507-041	SKIDTUBE ASSEMBLY
1	D2902-150	EXTRUSION
1	D2905-3	CAP
1	D2905-3	CAP
4	D3482-041	PLUG ASSEMBLY
4	D3482-043	PLUG ASSEMBLY
2	D3482-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
2	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3505-1	DOUBLER
2	D3505-3	DOUBLER
1	D4918-1	WEARPLATE
1	D4918-3	WEARPLATE
1	D4918-5	WEARPLATE
1	D4918-047	WEARPLATE
38	AEI S-1032-130	INSERT
1	AEI S-1032-225	INSERT
31	AN3024	BOLT
2	AN3054	BOLT
2	AN529C1032-10	SCREW
53	AN880C10L	WASHER
12	ME20601ADAWS	RIVET

GENERAL NOTES:
1) MATERIAL: N/A
2) FINISH: N/A

D3505-1 WEB (REF 4.2, 4.3, 4.4) AND PAINT WHITE PER DART QSI 005 4.2.
OPTIONAL: POWDER COAT WHITE (REF 4.3, 5.3) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTERLINE PER DART QSI 005 4.4 (OPTIONAL)

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED

5) IDENTIFICATION: IDENTIFY WITH DART BN PER DART QSI 044 8.4 (VIBRATING)

6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

7) WELDING TO BE DONE PER DART QSI 004

8) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND

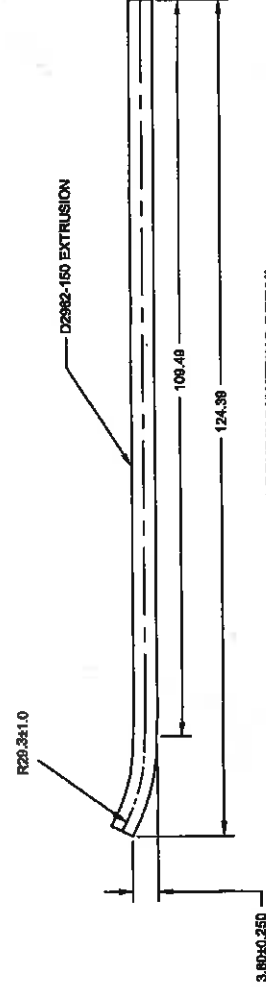
9) WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/281 ADHESIVE PER

10) USE DART DRILL TEMPLATE DT8888 TO LOCATE AND DRILL Ø0.287 HOLES (Ø8

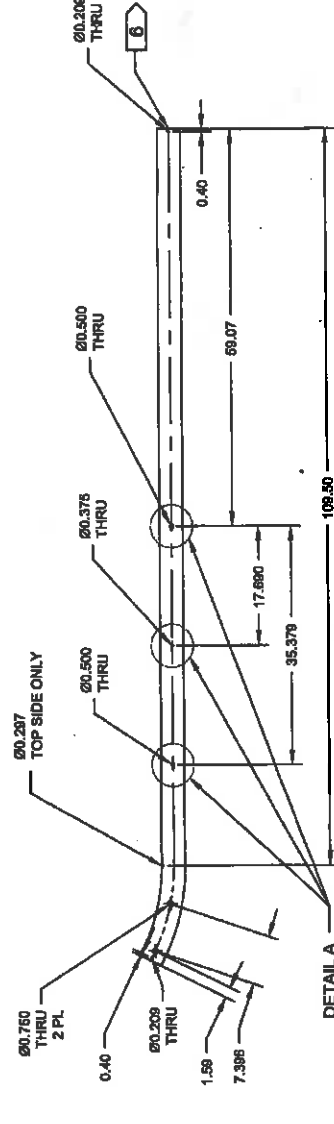
PLACES) FOR PERMANENT BOND WEARPLATE BOLTS WITH SIKAFLEX-241/281.

11) DO NOT INSTALL AN304 BOLTS AND AN880C10L WASHERS IN INDICATED

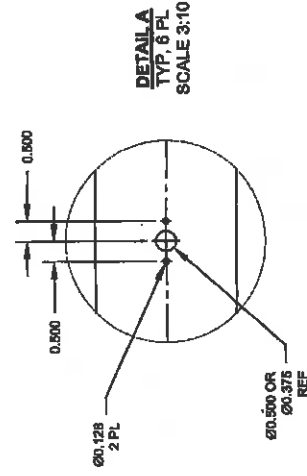
LOCATIONS



D3507-1 BENDING/CUTTING DETAIL



D3507-1 DRILLING DETAIL



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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 203381 MCL
19-11-18

D	REMOVE D3505-X GASKETS. D4918-X WAS D3505-X REVISE FINISH TO ADD PAINT AS THE PREFERRED FINISH, REVISED NOTES	DW	13.08.50
C	ADD D3504-5, FOR SKID GEAR DEFLECTOR. CHANGE FWD CAP BOLT TO AN529C1032-10 SCREW	DC	07.08.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DW		
DRAWN	DW		
CHECKED	W		
MFG. APPR.	D3507		
APPROVED	W		
DE APPR.	W		
DATE	13.08.30		
DART AEROSPACE USA, INC KENT, WA		REV. D	SHEET 1 OF 2
DRAWING NO. D3507		TITLE	EC 135 SKIDTUBE
SCALE		SCALE	NTS

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Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Quality ☐					
Date :	Sequence #:	QTY Affected :		MRB (QS1042)					
Description Work Order Deviation				Disposition					
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors				FAULT CATEGORY Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details: Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread					
Completed By				Lead hand / Supervisor					
QC / QA Coordinator									